

Work Order ID 59311

Monday, May 31, 2010 2:26:50 PM



Page 1

Item ID: D350-567-015

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Window Installation, Small

Start Date: 5/31/2010 Start Qty: 2.00



Required Date: 6/4/2010 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference: Return 2010 / RA110043

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date: 1005-31

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev D

100

0.00



QC 5

Quality Control

Memo

0.00

Original B31410 @ CHG001

It was found that 1 kit was complete & the hardware was loose & all mixed up: the bagging came un-done.

5/20/10/28 +2

110

Pick Kit

0.00



Packaging

Packaging

Memo

0.00

-New labels & paperwork required with the new batch # & now to be updated to CHG002.

-Remove the original D2125 windows & scrap them: Advise & show QC.

-Pick new hardware as necessary, for the 1 kit, & replace the D2125 windows to upgrade to CHG002.

001 w

10-6-38

DART			
TRANSPORT CANADA APPROVAL # 09-89			
TEL: 1-613-632-3336		FAX: 1-613-632-4443	
P/N	D350-567-015	CHG	CHG001
DESC.	Floor Window Kit, Sm	STC	SH92-18
LOT	B31410	STC	SH989NE
MODEL	AS350/355	STC	SH990NE
MADE IN CANADA			

DART			
TRANSPORT CANADA APPROVAL # 09-89			
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P/N	D350-567-015	CHG	CHG001
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC4- 100% Inspect kits for completeness Memo Ensure Original D2125 windows have been scraped & replaced with the current revision.	0.00 0.00							
130 Packaging Packaging	Identify as per dwg & Stock Location: <u>23</u> Memo	0.00 0.00							
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

8-06-06 x2

10-0-3 SP

h 10-07-06

Picklist Print

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Work Order ID: 59311

Parent Item: D350-567-015

Parent Item Name: Floor Window Installation, Small

Comments: IPP Rev:B Removed Manufacturing 05-11-17 JLM
IPP Rev:C 08-10-07 as per revD DD verified by:

Start Date: 5/31/2010

Required Date: 6/4/2010

Start Qty: 2.00

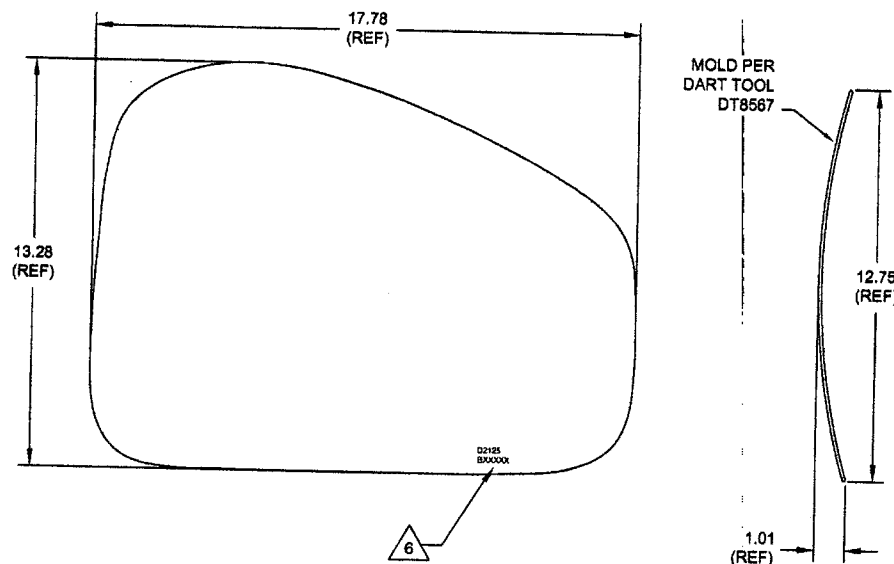
Required Qty: 2.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
D350-567-013		Manufactured	No			120	Each	3.0000	1	2			
Replacement Window, Small													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						MEZZ	3						
						23810	3						
D350-567-031		Manufactured	No			120	Each	0.0000	1	2			
Interior Floor Window (Sliding Door Compatible)													
DT8439		Manufactured	No			120	Each	0.0000	1	2			
template													

N/A

N/A

10-6-3sf *(2x)*



D2125 FLOOR WINDOW
(FLAT TEMPLATE)

D2125 FLOOR WINDOW:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D2125" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 0.98 +/- 0.22 LBS
- 8) FLAT ROUGH SIZE: 13.3 x 17.8 x 0.13
- 9) MOLD PER DART TOOL DT8567

REFERENCE ONLY

RELEASED
07.07.18

REV.	DESCRIPTION	BY	DATE
C	REDRAWN PER PAR 187	DC	07.07.18
B	CREATE DWG. UPDATE MTL PER NCR 029	MB	06.04.19
A	ADDED PICTURE WITH OVERALL DIMS	KE	99.03.09
-	NEW ISSUE	BW	92.03.03
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	JB		
MFG. APPR.	AP		
APPROVED	AP		
DE APPR.	AP	DRAWING NO. D2125 TITLE 350/355 FLOOR WINDOW SCALE NTS	
DATE	07.07.18	<small>COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Part Number D350-567-013/-015/-025/031
Description FLOOR WINDOW KITS

Part Number D350-567-013/-015/-025/031
Description FLOOR WINDOW KITS

REFERENCE ONLY

ENGINEERING CHANGE NOTICE **DART AEROSPACE LTD**

Date: 07.07.23	Job No.:	ADR Yes/No: Y	ADR Date: 07.07.23	ECN #: 999
Product No.: D350-567, D412-694, D412-709		Created By: <i>SP</i>	Approved By: <i>MP</i>	
Product Name: WINDOW INSTALLATIONS		Checked By: <i>h</i>	General Manager Approval:	

Distribution	Reqd	Resp	Received
Production Manager	Y	LL	07/09/27
Production Engineering Coord	Y	EC/DD	EC
Director Quality Assurance	N		
Customer Order Processing	N		

Distribution	Reqd	Resp	Received
Customer Technical Support	N		
Marketing	N		
Prod Eng Coord	Y	DL	HL

Reason for Change: PREVIOUSLY OUTSOURCED PRODUCT DOES NOT MATCH DRAWINGS AND TEMPLATES ARE OUT OF TOLERANCE.

Documents Affected:
RELEASE D2125 REV. C
D2958 REV. E
D3136 REV. E
D3290 REV. C

REFERENCE ONLY

#	Engineering Actions	Reqd	Resp	Notes	Complete
1	Required Documents/Drawings Under Review	Y	KJ/MB		07.09.27
2	Update Blue/Pink/DSI Folder and Electronic Files	N/A			
3	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	MB/DC		07.09.27
4	Update Grey Project Binder	Y	KJ/DC		07.09.27
5	Move Electronic Files	Y	KJ		07.09.27
6	Update Master Document List (MDL)	N	KJ		07.09.27
7	Update Document Record (DR) <i>Rev G/J/G</i>	Y	KJ		07.09.27
8	Create/Update Change Record Form	Y	KJ	567/694/709	07.09.27
9	Create/Update PPP's	N/A	KJ	SEE ATTACHED SHEET FOR CHG #'S	07.09.27
10	Update Controlled PDF Files	Y	KJ		07.09.27
11	Notify TC/FAA of Change	N/A			07.09.27
12	Update QSI 021 and/or STC Approval List	N/A			
13	Update Product Development Summary	N/A			
14	Update Accpac Database	N/A			
15	Update Access (ARC) Database	N/A			
16	Update/Verify ARC	N/A			
17	Update Paperwork Kits in Production	N/A			
18	Update Qpulse/Laminated Dwgs	N/A			
19	Update Product Compatability Matrix	N/A			
20	Create Eurocopter Form (FEE)	N/A			
21					

#	Production Actions	Reqd	Resp	Notes	Complete
22	Create/Update Coss IPP/BOM	Y	JLM/EC		07.09.28
23	Update FAI Sheets	Y	JLM/EC	D3290	07.09.28
24	Create/Update CNC Programs	Y	DL	(D3290-1)	07.09.28
25	Create/Update Tooling	N/A			07.09.28
26	Red Tag Stock (Specify)	N/A	JM	Red TAG OLD STOCK	07.10.02
27	Rework/Scrap Current Production and/or Stock	N/A			
28	Update Paperwork Kits in Stock	N/A			
29	Create/Update MPP	N/A			
30					

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
31	Notify Previous Customers	N/A			
32	Notify Eurocopter France	N/A			
33					

Description / Action:
UPDATE AND RELEASE D2125 REV. C, D2958 REV. E, D3136 REV. E, D3290 REV. C

ECN # 999
NEW CHANGE NUMBERS FOR 9-DIGITS

07.09.24

DC

DRAWING	REVISION	KITS AFFECTED	INCREASE CHG# TO:
D2125	C	D350-567-013 ✓	002
		D350-567-015 ✓	002
D2958	E	D350-567-021 ✓	004
		D350-567-023 ✓	002
		D350-567-025 ✓	002
D3136	E	D412-694-015 ✓	002
		D412-709-019 ✓	002
D3290	C	D350-567-111 ✓	002
		D350-567-113 ✓	002

REFERENCE ONLY

PART NUMBER	CHG #	Qty IN STOCK	IN PRODUCTION	BATCH # IN PRODUCTION
D350-567-013	001	7	0	
D350-567-015	001	11	0	
D350-567-021	003	0	2	B27451, B34372
D350-567-023	001	5	0	
D350-567-025	001	2	5	B33952
D350-567-111	001	1	2	B34852
D350-567-113	001	0	2	B34852A
D412-694-015	001	10	0	
D412-709-019	001	9	0	

All batches in stock and in production batches shown above as of 07/09/28 will have to be red tagged.

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Reference: Return 2010 / RA110043

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date: 1005-31

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev D

100

0.00



QC 5

Quality Control

Memo

0.00

Original B31410 @ CHG001.

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8/10/5/28 +2

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upgrade to CHG002.

CL 101611

REFERENCE ONLY

Item ID	Rev	Name	Start Date	Quantity	Pe	UOM	op	Date	Seg	Scrap %	Qun	meid	N	EC ID	CX I	Sort	Offin	Ty	Per	h	to	re	Cate	Last	Mold	De
AN526C632R12	1	Screw M104240	1/01/08	8.0000		Each		120		0 %	0.					0	0	MR					12/05/0...	1...		
AN960JD6		Washer M104537	1/01/08	8.0000		Each		120		0 %	0.					0	0	MR					12/05/0...	1...		
D2463 2454 unigress		Seal B5561	12/05/09	3.7500	f			120		0 %	0.					0	0	MR					12/05/0...	1...		
D3210-1		Doubler	12/05/09	1.0000		Each		120		0 %	0.					0	0	MR					12/05/0...	1...		
D3211-1	1	Bracket	12/05/09	1.0000		Each		120		0 %	0.					0	0	MR					12/05/0...	1...		
D3212-1	✓	Floor Window	12/05/09	1.0000		Each		120		0 %	0.					0	0	MR					12/05/0...	1...		
D3213-041	1	Door Assembly	12/05/09	1.0000		Each		120		0 %	0.					0	0	MR					12/05/0...	1...		
DT8439	1	template	1/01/08	1.0000		Each		120		0 %	0.					0	0	MR					12/05/0...	1...		
MS20470AD4-5	M113916	Rivet, Universal Head	1/01/08	40.0000		Each		120		0 %	0.					0	0	MR					12/05/0...	1...		
MS20470AD4-6	M113644	Rivet, Universal Head	1/01/08	90.0000		Each		120		0 %	0.					0	0	MR					12/05/0...	1...		
MS20470AD4-7	M112492	Rivet, Universal Head	1/01/08	20.0000		Each		120		0 %	0.					0	0	MR					12/05/0...	1...		
MS21042L06		Nut M114330	1/01/08	8.0000		Each		120		0 %	0.					0	0	MR					12/05/0...	1...		

-031

REFERENCE ONLY

W10 55311
D 350-567-015